

RECOMMENDED USE

Oatey®**SOLVENT CEMENT SPECIFICATIONS**

NOTES:

1. Values (cure) indicate time in hours before 1/2 and full line pressure in psi can be applied at given application temperatures.
2. Lap Shear data obtained using ASTM test method D1084 which measures compressive shear in lbs. per sq. inch (psi) required to break adhesive band of a 1-inch sq. lap joint. (ASTM req. for PVC 2 hrs.-250 psi, 16 hrs.-500 psi, 72 hrs.-900 psi. For ABS-48 hrs.-800 psi.)
3. Viscosity measurements using Brookfield Viscometer Model RVF-E, Spindle No. 3 at 10 RPM.
4. Evaporation rates determined by measuring drying speed of a coating of cement 20 thousandths of an inch thick on a glass surface. Variables in the field will affect these values.
5. Hydrostatic burst strength test values per ASTM D-2564; D-2846.

Oatey®

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Lap Shear	2 HOURS	250 psi	2 HOURS	Lap Shear
	16 HOURS	>500 psi	16 HOURS	
	72 HOURS	>900 psi	72 HOURS	
Viscosity at 72° F as manufactured	2000 cps	Viscosity at 72° F as manufactured		
Set-Up Time: (Evaporation Rate)	30 - 50° F	5-6 minutes	30 - 50° F	Set-Up Time: (Evaporation Rate)
	50 - 70° F	3-4 minutes	50 - 70° F	
	70 - 90° F	1-2 minutes	70 - 90° F	
Meets ASTM Specifications	40 - 100° F	Meets ASTM Specifications		
Use Temperature Range °F	Any diameter pipe up through 6"	Use Temperature Range °F		
Maximum Pipe Diameter at recommended temp.		Maximum Pipe Diameter at recommended temp.		
Hydrostatic Burst Strength Values	100° F	2 hrs. - 12 hrs.	100° F	Hydrostatic Burst Strength Values
	40° F	4 hrs. - 24 hrs.	40° F	
	20° F	16 hrs. - 96 hrs.	20° F	

150 psi | 300 psi
LINE PRESSURE

ASC12489

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